



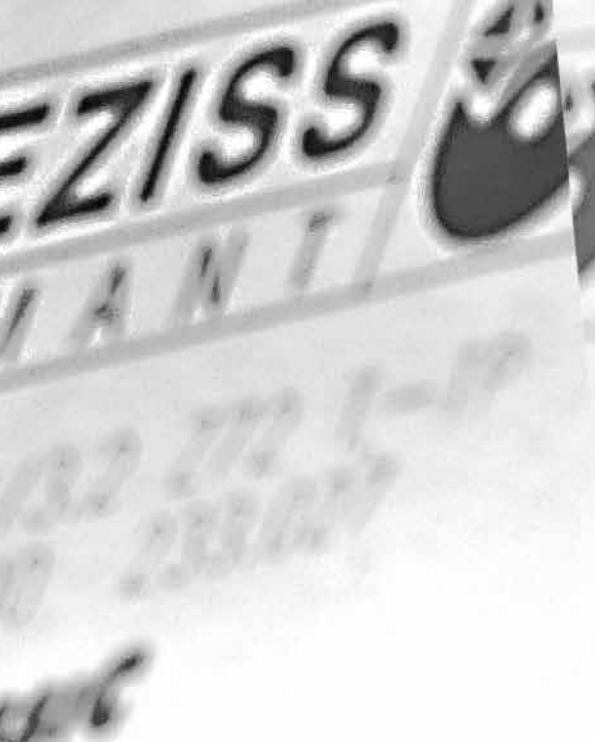
**PRE**  
**D.I.A.**

150/75/4  
max 500

*CLASS*

## SAW BLADES

	PAGE
<b>TECHNICAL INFORMATION</b>	10-12
<b>CLASSIC</b> PCD saw blade for beam saw	13
<b>ATTACK PLUS</b> PCD saw blade for beam saw	14
<b>CONIC</b> Conical PCD scoring blade for beam saw	15
<b>CLASSIC</b> PCD saw blade for panel sizing machine	16
<b>ATTACK</b> PCD saw blade for panel sizing machine	17
<b>CONIC</b> Conical PCD scoring blade for panel sizing machine	18
<b>RAY II</b> Adjustable PCD scoring blade for panel sizing machine	19
<b>CLASSIC 4,4</b> <i>Set of saw blades</i> PCD saw blades for vertical panel sizing machine	20
<b>ATTACK PLUS</b> <i>Set of saw blades</i> PCD saw blades for vertical panel sizing machine	21
<b>CLASSIC 3,2</b> <i>Set of saw blades</i> PCD saw blades for vertical panel sizing machine	22
<b>ATTACK PLUS</b> <i>Set of saw blades</i> PCD saw blades for vertical panel sizing machine	23
<b>CLASSIC PCD</b> PCD saw blade for multirip machine	24
<b>ATTACK PCD</b> PCD saw blade for multirip machine	25



**SAW BLADES AND SCORING BLADES FOR BEAM SAWS**

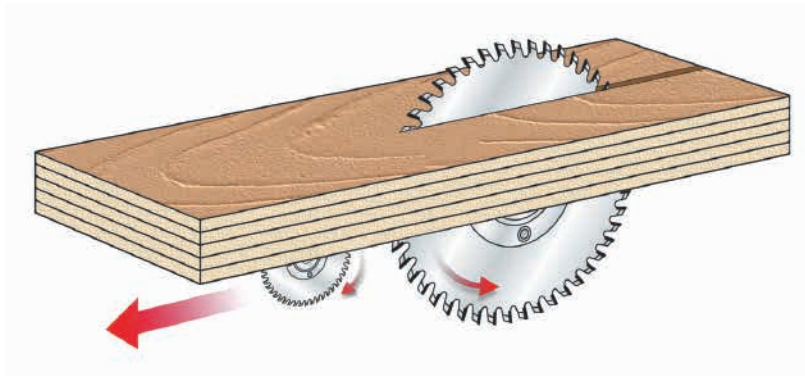
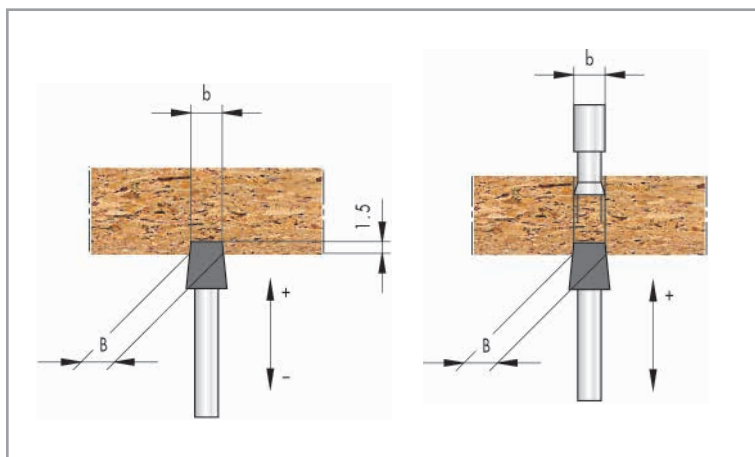


Diagram of the feed and the rotation of the saw blade and the scoring blade in a beam saw.



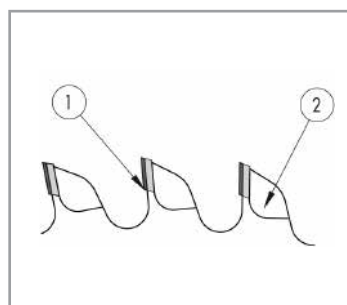
For the correct adjustment of thickness, it is advisable to sharpen both the saw and the scoring blade as a set.

**PREZISS RESHARPENING SERVICE GUARANTEES THIS.**

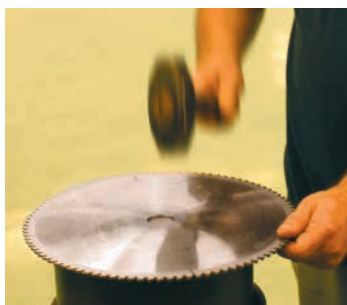
b= kerf

B = width is adjusted to the real cut of the saw, 0,5 mm depth in the scoring blade means 0,1 m/min of increment on the incision width = B

**MANUFACTURE GUARANTEE**

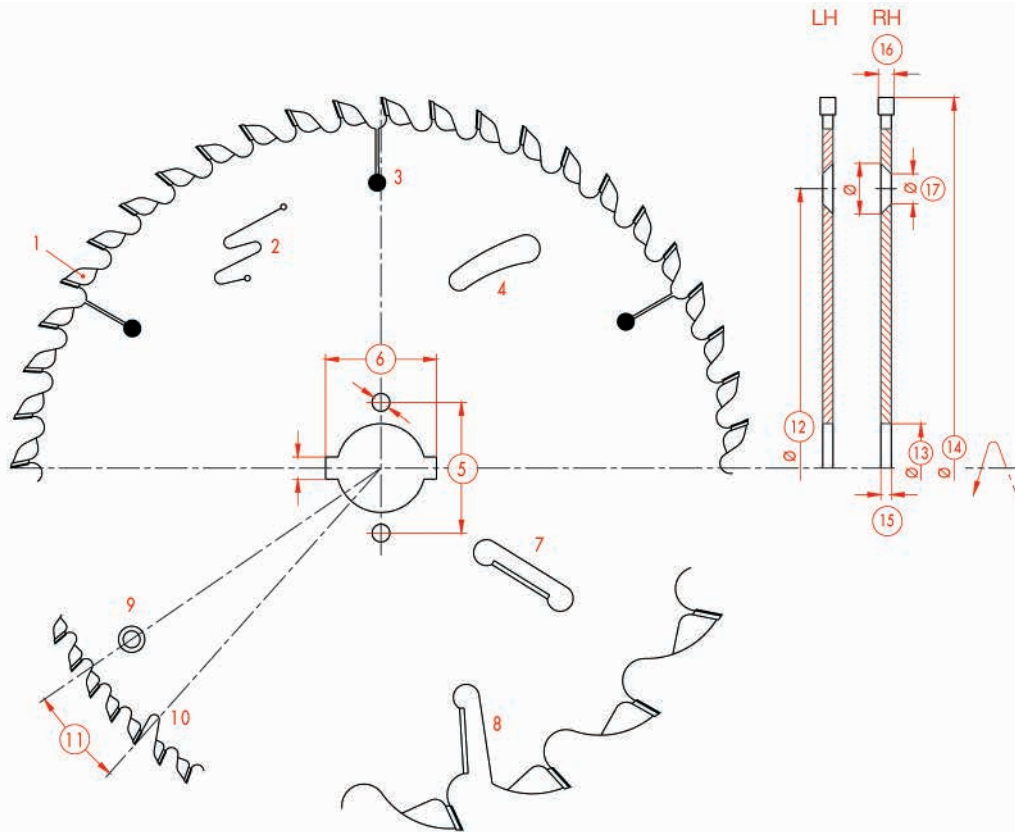


- Blade body of special steel.
- Thermal treatment, tensioned and flattened specifically for brazed PCD saw blades.
- Shape of seats and security tips (1).
- Body release to improve the side clearance (2).
- Expansion slots with copper protection or antibreak epoxy resin.
- Long lasting and antirust galvanized coating.



**SAW BLADES WITH PCD TIPS**

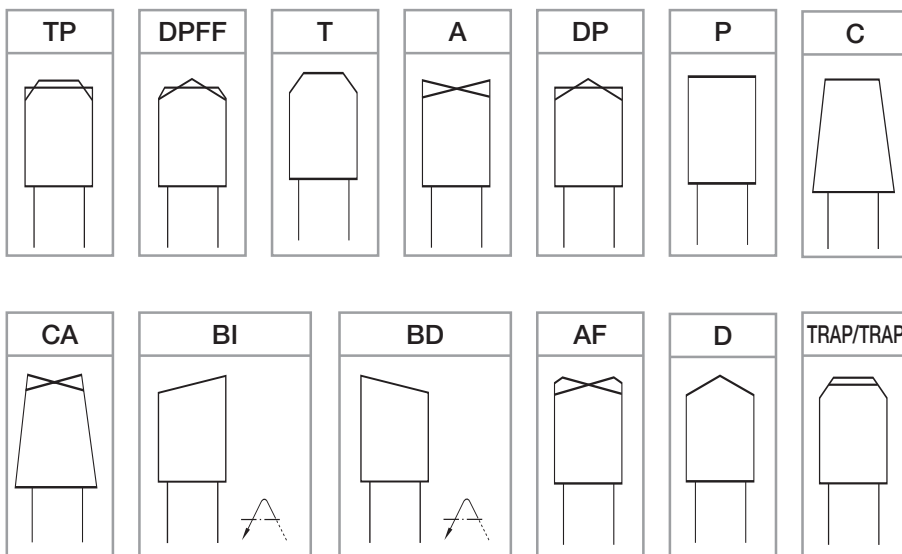
**NAMING OF SECURITY AND ADDITIONAL ELEMENTS**



1. Side body clearance
2. Low noise laser slots
3. Expansion slot with copper plugs
4. Cooling slots
5. Pin holes
6. Keyway
7. Internal wiper slots
8. Exterior wiper slots
9. Countersunk holes for clamping screws
10. Opening for allocating hogger segment
11. Positioning angle for holes (9) and openings (10)
12.  $\varnothing$  Pin holes bold circle > INDICATE NUMBER OF HOLES
13.  $\varnothing$  bore
14.  $\varnothing$  diameter
15. Body thickness
16. Kerf
17.  $\varnothing$  Countersunk holes

10

**TOOTH TYPES**



		Code
TP	TRIPLE CHIP GRIND	01
DPFF	FLAT / INVERTED "V" WITH DOUBLE BEVEL	02
T	TRIPLE CHIP	03
A	ALTERNATE	04
DP	INVERTED "V" / FLAT	05
P	FLAT	06
C	CONICAL	07
CA	CONICAL ALTERNATE	08
BI	LEFT BEVEL	09
BD	RIGHT BEVEL	10
AF	ALTERNATE / CHAMFER	11
D	INVERTED "V"	12
TRAP/ TRAP	TRAPEZOIDAL / TRAPEZOIDAL	13

The characteristics required for a high quality diamond saw blade for both the cut and sizing of any kind of board, must be: primarily a perfect cut and long life at the most effective cutting speed.

With our experience we have developed two types of saw blades called **CLASSIC** and **ATTACK**, which, with identical quality and precision level, cover all cut needs and demands. The main difference between these two types of blade is the height of the PCD tips, which allow them the same cut quality and durability between re-sharpenings. The height only influences the number of re-sharpenings possible.

The selection of the saw blade, type **CLASSIC** (greater height) or **ATTACK** (reduced height) should be done in this order:

- Investment
- Work requirements
- Working materials

## PERIPHERIAL SPEED TABLE

Dia. Ø  
(mm)

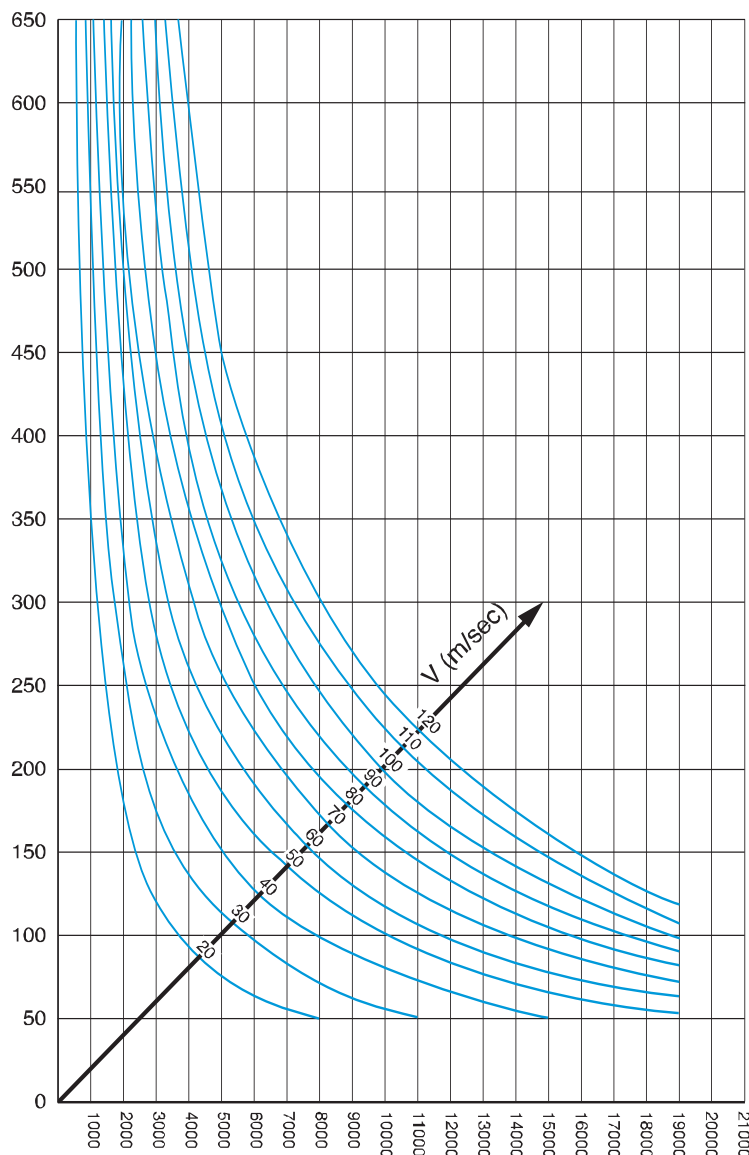


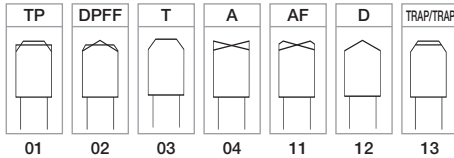
Table to calculate the diameter of the saw blade in relation to the material to be machined and the peripheral speed (m/sec).

RECOMMENDED SPEED FOR:	
<span style="color: #0070C0;">■</span>	Hard wood . . . . .80-90 m/sec.
<span style="color: #0070C0;">■</span>	Chipboards . . . . .60-80 m/sec.
<span style="color: #0070C0;">■</span>	Faced MDF . . . . .30-60 m/sec.
<span style="color: #0070C0;">■</span>	Hard fiber board . . . .40-60 m/sec.
<span style="color: #0070C0;">■</span>	Thermoplastic board . .30-70 m/sec.
<span style="color: #0070C0;">■</span>	Duroplastic board . . .15-50 m/sec.

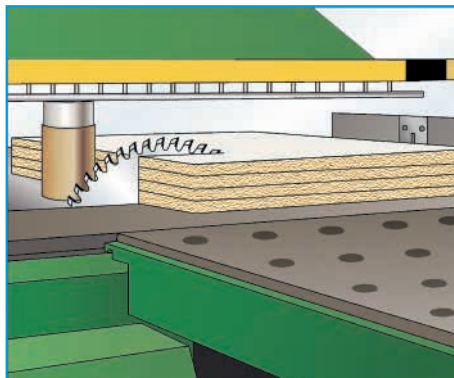


**PCD SAW BLADE FOR BEAM SAW**

High performance



ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
300	30/75	4,4/3,2	48	1001001
300	30/75	4,4/3,2	54	1001002
300	30/75	4,4/3,2	72	1001003
300	30/80	4,4/3,2	60	1001004
300	30/75/80	4,4/3,2	96	1001005
350	30/75/80	4,4/3,2	54	1001006
350	30/75/80	4,4/3,2	64	1001007
350	30/75/80	4,4/3,2	72	1001008
350	30/60/75/80	4,4/3,2	96	1001009
380	60	4,8/3,5	72	1001017
380	60	4,8/3,5	84	1001018
400	30/60/75/80	4,4/3,2	64	1001010
400	30/60/75/80	4,4/3,2	72	1001011
400	30/60/75	4,8/3,5	72	1001019
400	30/60/75/80	4,4/3,2	84	1001012
400	30/60/75/80	4,4/3,2	96	1001013
420	60	4,4/3,5	72	1001026
420	60	4,8/3,5	72	1001020
420	60	4,8/3,5	84	1001021
430	60/75/80	4,8/3,5	72	1001014
430	75	4,8/3,2	96	1001015
450	30/60/75/80	4,8/3,6	72	1001016
450	60/80	4,8/3,6	72	1001022
480	80	4,8/3,5	72	1001027
500	60	4,8/3,6	64	1001023
550	60	5,8/4,0	64	1001024
600	60	5,8/4,0	72	1001025

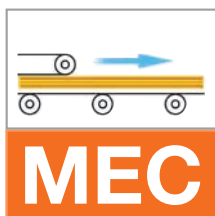


**APPLICATION**

- In beam saws, suitable for cutting chipboard individually or in packs together with a scoring blade.
- To cut boards made of chipboard, fibreboard, composite materials, plastics, cement reinforced with fibres, etc. for rough cut or finished cut.

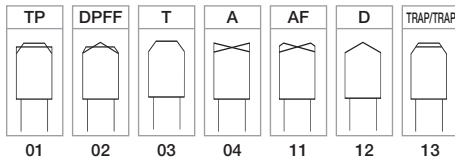
**DESCRIPTION**

- High performance tool.
- The number and shape of the teeth as well as the geometry of the cut depend on the thickness of the material to be cut, the feed speed and the finish required.
- Proportionally dimensioned tips to achieve optimum performance.
- Other sizes on request.

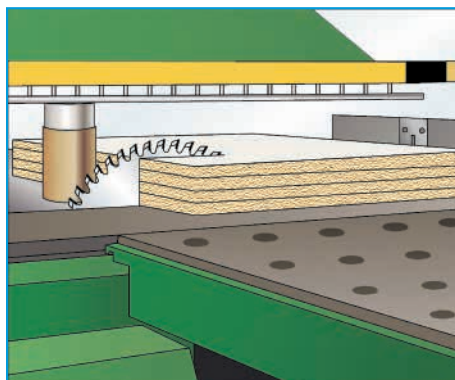


**PCD SAW BLADE FOR BEAM SAW**

Economical



ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
300	30/75	4,4/3,2	48	1002001
300	30/75	4,4/3,2	54	1002002
300	30/75/80	4,4/3,2	72	1002003
300	30/75/80	4,4/3,2	60	1002004
300	30/60/75/80	4,4/3,2	96	1002005
350	30/75/80	4,4/3,2	54	1002006
350	30/75/80	4,4/3,2	64	1002007
350	30/60/75/80	4,4/3,2	72	1002008
350	30/75/80	4,4/3,2	96	1002009
380	60	4,8/3,5	72	1002017
380	60/80	4,8/3,5	84	1002018
400	30/60/75/80	4,4/3,2	64	1002010
400	30/60/75/80	4,4/3,2	72	1002011
400	30/60/75	4,8/3,5	72	1002019
400	30/60/75/80	4,4/3,2	84	1002012
400	30/60/75/80	4,4/3,2	96	1002013
420	60	4,4/3,5	72	1002024
420	60	4,8/3,5	72	1002020
420	60	4,8/3,5	84	1002021
430	60/75/80	4,4/3,5	72	1002014
430	30/80	4,8/3,5	72	1002026
430	75	4,4/3,2	96	1002015
450	30/60/75	4,8/3,6	72	1002016
450	60/80	4,8/3,6	72	1002022
480	80	4,8/3,5	72	1002025

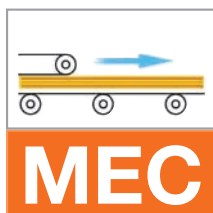


**APPLICATION**

- In beam saws, suitable for cutting chipboards individually or in packs together with a scoring blade.
- To cut chipboard, fibreboard, composite materials, plastics, cement reinforced with fibres, etc. for rough cut or finished cut.

**DESCRIPTION**

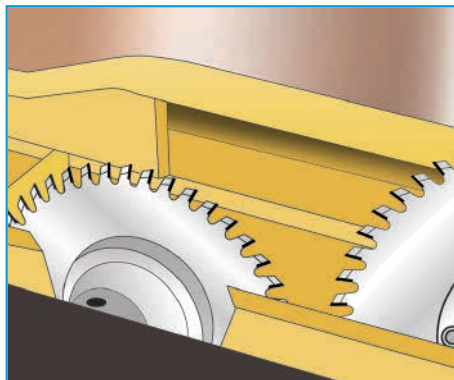
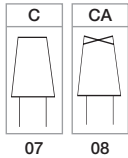
- Economical high performance tool.
- The number and shape of the teeth as well as the geometry of the cut depend on the thickness of the material to be cut, the feed speed and the finish required.
- Proportionally dimensioned tips to achieve optimum performance.
- Other sizes on request.



**PCD SCORING BLADE FOR PANEL BEAM SAW**



ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE	
125	22		4,4/5,4	18	1003001	
125	22		4,4/5,4	24	1003002	
125	45		4,4/5,4	20	1003003	
125	45		4,4/5,4	24	1003004	
125	45		4,4/5,4	28	1003005	
150	30		4,4/5,4	24	1003006	
150	45		4,4/5,4	24	1003007	
150	30/45		4,4/5,4	30	1003008	
160	45		4,4/5,4	28	3/11/70	1003009
160	55		4,4/5,4	28	3/7/66	1003020
180	20		4,4/5,4	30		1003010
180	30		4,4/5,4	30		1003011
180	45		4,4/5,4	30		1003012
180	45		4,8/5,8	36		1003013
180	50		4,4/5,4	30	3/13/80	1003021
180	55		5,0/6,0	30		1003014
200	20/45/65		4,4/5,4	36		1003015
200	45/65/80		4,8/5,8	36		1003016
215	50		4,4/5,4	42	3/15/80	1003017
215	50		4,4/5,4	36	3/15/80	1003018
215	50		4,8/5,8	36	3/15/80	1003019
300	50		4,4/5,4	48	3/15/80	1003022

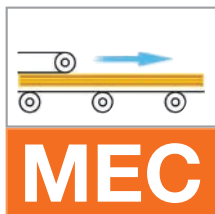


**APPLICATION**

- In beam saws, operates as a pre-scoring saw blade on the underside of the panel.
- For all materials described in the saw section.

**DESCRIPTION**

- Proportionally dimensioned tips to achieve optimum performance.
- Other sizes on request.



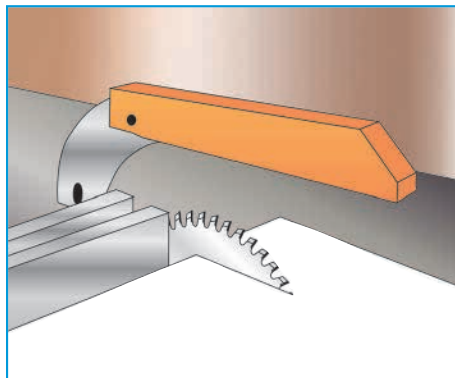
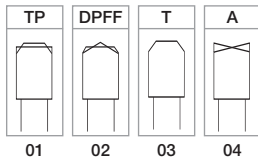


**PCD SAW BLADE FOR PANEL SIZING MACHINE**

High performance



ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE
200	30	3,2/2,2	24		1004001
200	30	3,2/2,2	64		1004002
220	30	3,2/2,2	42		1004003
220	30	3,2/2,2	64		1004004
250	30	3,2/2,2	48	2/10/60+2/7/42	1004005
250	30	3,2/2,2	60	2/10/60+2/7/42	1004006
250	30	3,2/2,2	80	2/10/60+2/7/42	1004007
300/303	30	3,2/2,2	48	2/10/60+2/7/42	1004008
300/303	30	3,2/2,2	60	2/10/60+2/7/42	1004009
300/303	30	3,2/2,2	72	2/10/60+2/7/42	1004010
300/303	30	3,2/2,2	84	2/10/60+2/7/42	1004011
300/303	30	3,2/2,2	96	2/10/60+2/7/42	1004012



**APPLICATION**

- A multipurpose blade, giving a perfect, precision cut on all types of materials including M.D.F., chipboard whether covered or plain, veneered boards, plastics, acrylics, hard and abrasive laminates, materials containing glass or carbon fibre, aluminium profiles and sheets, PVC, etc.

**DESCRIPTION**

- Cut width 3,2 mm.
- A well-tested blade combining precision mechanical characteristics with dimensioned PCD teeth.
- Exceptional price/performance relationship offering extraordinary results.
- Other sizes on request.

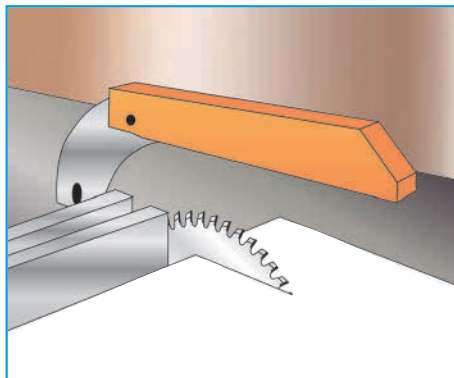
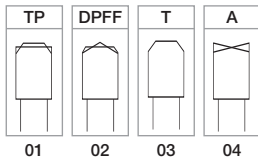


**PCD SAW BLADE FOR PANEL SIZING MACHINE**

Economical



ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE
200	30	3,2/2,2	24		1005001
200	30	3,2/2,2	64		1005002
220	30	3,2/2,2	42		1005003
220	30	3,2/2,2	64		1005004
250	30	3,2/2,2	48	2/10/60+2/7/42	1005005
250	30	3,2/2,2	60	2/10/60+2/7/42	1005006
250	30	3,2/2,2	80	2/10/60+2/7/42	1005007
300/303	30	3,2/2,2	48	2/10/60+2/7/42	1005008
300/303	30	3,2/2,2	60	2/10/60+2/7/42	1005009
300/303	30	3,2/2,2	72	2/10/60+2/7/42	1005010
300/303	30	3,2/2,2	84	2/10/60+2/7/42	1005011
300/303	30	3,2/2,2	90	2/10/60+2/7/42	1005012
300/303	30	3,2/2,2	96	2/10/60+2/7/42	1005013



**APPLICATION**

- Suitable for all types of materials including M.D.F., chipboard whether covered or plain, veneered boards, plastics, acrylics, hard and abrasive laminates, materials containing glass or carbon fibre, aluminium profiles and sheets, PVC, etc.

**DESCRIPTION**

- Cut width 3,2 mm
- Long-lasting producing perfectly finished cut.
- Very economical price/performance relationship.
- Wide range of sizes and tooth numbers, covering every requirement.
- Other sizes on request.

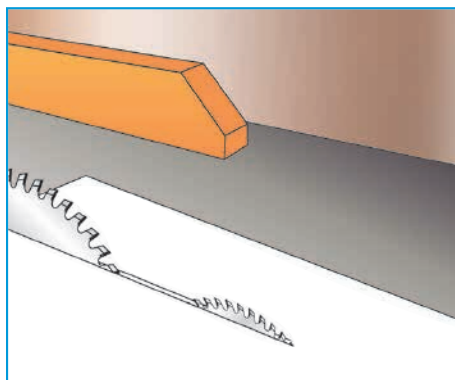
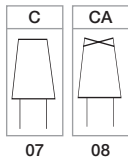


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**PCD SCORING BLADE FOR PANEL SIZING MACHINE**



ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
100	22	3,2/4,2	18	1006001
120	20/22	3,2/4,2	18	1006002
125	20/22/45	3,2/4,2	18	1006003
125	20/22/45	3,2/4,2	24	1006004
150	20/22/45	3,2/4,2	24	1006005
150	20/22/45	3,2/4,2	30	1006006
150	20/22/45	3,2/4,2	36	1006007



**APPLICATION**

- Works as scoring blade ahead of the principal cut on the underside of the panel.
- Cutting with the feed.
- It acts as the perfect partner to the “CLASSIC®” or “ATTACK®” panel saw blades.

**DESCRIPTION**

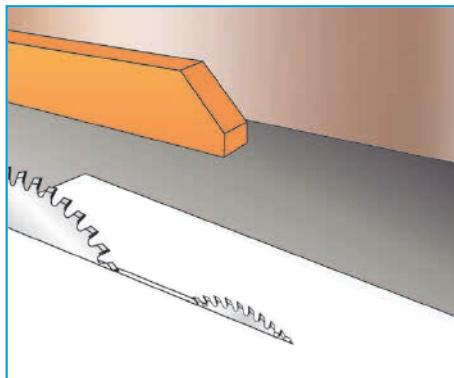
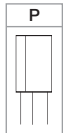
- Can be easily adjusted thanks to its conical shape and precision measurements.
- Long-lasting blade producing perfectly finished cut. The blade seldom requires re-calibration.
- Made from one piece with conical tips.
- Proportionally dimensioned tips to achieve optimum performance.
- Other sizes on request.



**ADJUSTABLE PCD SCORING BLADE FOR PANEL SIZING MACHINE**



ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE
<i>Striebig compact</i>					
80	20	2,8/3,6	10+10		1007001
<i>Altendorf/Striebig</i>					
100	20/22	2,8/3,6	12+12		1007002
<i>Martin</i>					
120	22	3,0/3,9	12+12	2/4,5/42+ 2/4,5-9/39	1007003
<i>Altendorf</i>					
120	22	3,0/3,9	12+12		1007004
<i>SCM / Holz-her</i>					
120	20	2,8/3,6	12+12		1007005
<i>Altendorf</i>					
120	50	2,8/3,6	12+12	4/6-10/62	1007006
125	20	2,8/3,6	12+12		1007007
<i>Altendorf</i>					
125	50	2,8/3,8	12+12	4/6-10/62	1007008



**APPLICATION**

- Especially designed to work as a scorer ahead of the main cut on the underside of the panel.

**DESCRIPTION**

- Made in two parts pinned through blade and with space rings.
- Cutting with the feed.
- The ideal partner of "CLASSIC®" and "ATTACK®" saw blades.
- Long-lasting blades that do away with the need to repeatedly re-adjust the tungsten scoring blades.
- Other sizes on request.

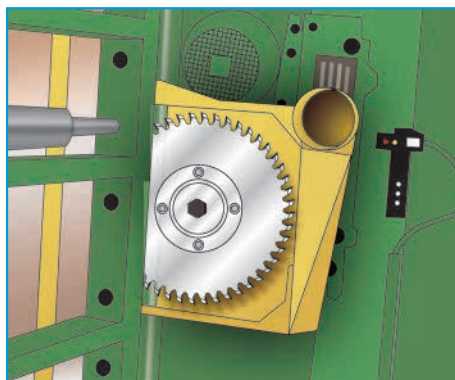
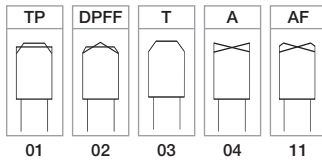


**PCD SAW BLADES FOR VERTICAL PANEL SIZING MACHINE**

High performance

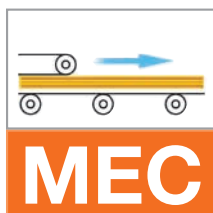


ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
Homag CVP 1012 300	75	4,4	96	1008001
Homag CVP 1012 300	75	4,48	96	1008002
Homag CVP 1012 300	75	4,4	72	1008003
Homag CVP 1012 300	75	4,48	72	1008004
Homag CVP 1012 125	45	4,4/5,4	18	1008005



**APPLICATION**

- In vertical panel sizing machines for the perfect cut of postforming panels.





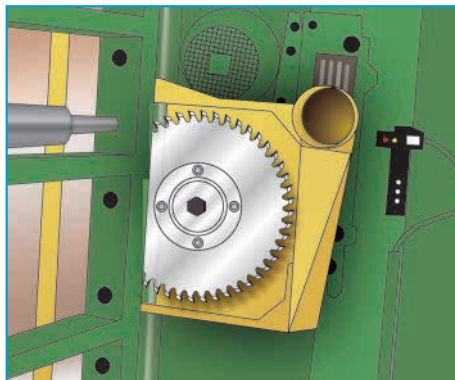
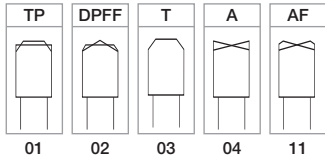
**PCD SAW BLADES FOR VERTICAL PANEL SIZING MACHINE**

Economical



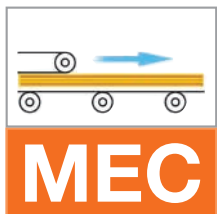
ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
Homag CVP 1012 300	75	4,4	96	1009001
Homag CVP 1012 300	75	4,48	96	1009002
Homag CVP 1012 300	75	4,4	72	1009003
Homag CVP 1012 300	75	4,48	72	1009004
Homag CVP 1012 125	45	4,4/5,4	18	1009005

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**APPLICATION**

- In vertical panel sizing machines for the perfect cut of postforming panels.

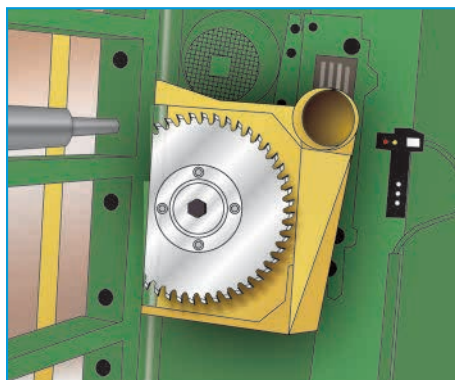
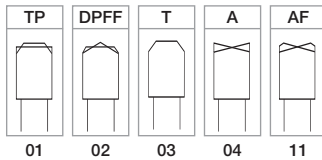


**PCD SAW BLADES FOR VERTICAL PANEL SIZING MACHINE**

High performance

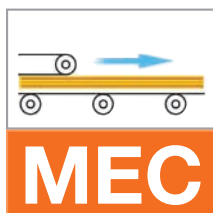


ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
Homag CVP 1012 300	75	3,2/2,2	96	1010001
Homag CVP 1012 300	75	3,28/2,2	96	1010002
Homag CVP 1012 300	75	3,2/2,2	72	1010003
Homag CVP 1012 300	75	3,28/2,2	72	1010004
Homag CVP 1012 125	45	3,2/4,2	18	1010005



**APPLICATION**

- In vertical panel sizing machines for the perfect cut of postforming panels.



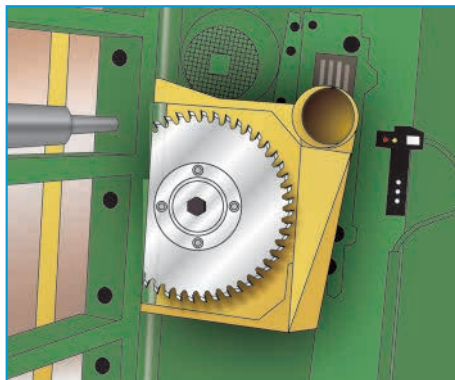
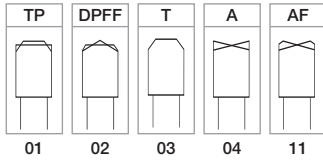
**PCD SAW BLADES FOR VERTICAL PANEL SIZING MACHINE**

Economical



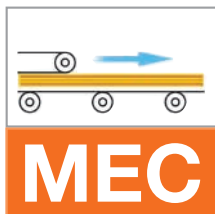
ØD mm	Ød mm	B mm	Z =	PRODUCT CODE
Homag CVP 1012 300	75	3,2/2,2	96	1011001
Homag CVP 1012 300	75	3,28/2,2	96	1011002
Homag CVP 1012 300	75	3,2/2,2	72	1011003
Homag CVP 1012 300	75	3,28/2,2	72	1011004
Homag CVP 1012 125	45	3,2/4,2	18	1011005

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**APPLICATION**

- In vertical panel sizing machines for the perfect cut of postforming panels.

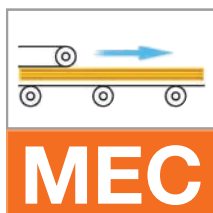
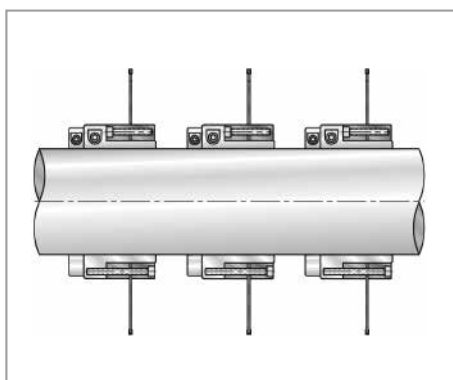
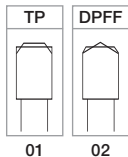


**PCD SAW BLADE FOR MULTIRIP MACHINE**

High performance



ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE
210	90	2,2/1,6	36	8/7/106	1012001
210	90	3,2/2,2	36	8/7/106	1012002
210	100	2,2/1,6	36	DKN	1012003
210	100	3,2/2,2	36	DKN	1012004
210	115	2,2/1,6	36	8/7/131	1012005
210	115	3,2/2,2	36	8/7/131	1012006
210	90	2,2/1,6	48	8/7/106	1012007
210	90	3,2/2,2	48	8/7/106	1012008
210	100	2,2/1,6	48	DKN	1012009
210	100	3,2/2,2	48	DKN	1012010
210	115	2,2/1,6	48	8/7/131	1012011
210	115	3,2/2,2	48	8/7/131	1012012
250	90	2,2/1,6	36	8/7/106	1012013
250	90	3,2/2,2	36	8/7/106	1012014
250	100	2,2/1,6	36	DKN	1012015
250	100	3,2/2,2	36	DKN	1012016
250	115	2,2/1,6	36	8/7/131	1012017
250	115	3,2/2,2	36	8/7/131	1012018
250	90	2,2/1,6	48	8/7/106	1012019
250	90	3,2/2,2	48	8/7/106	1012020
250	100	2,2/1,6	48	DKN	1012021
250	100	3,2/2,2	48	DKN	1012022
250	115	2,2/1,6	48	8/7/131	1012023
250	115	3,2/2,2	48	8/7/131	1012024



**APPLICATION**

- In multirip machines type “Paul”, “Wemhöner”, “I.S.E.”, etc.
- Suitable for the multiple cutting of decorative panels for the manufacture of laminated parquet and other materials.

**DESCRIPTION**

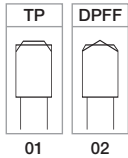
- Saw blade manufactured with a special steel body for PCD saws with braised tips of Polycrystalline Diamond model “CLASSIC®”.
- Nickel coating.
- PCD tip height = 6,0 mm.
- To achieve maximum performance, we advise mounting them on a hydro centric chuck **HYDRO PREZISS Series 6** (See page 141).

**PCD SAW BLADE FOR MULTIRIP MACHINE**

Economical

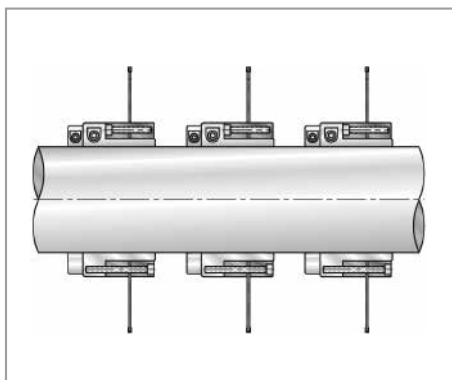


ØD mm	Ød mm	B mm	Z =	NL =	PRODUCT CODE
210	90	2,2/1,6	36	8/7/106	1013001
210	90	3,2/2,2	36	8/7/106	1013002
210	100	2,2/1,6	36	DKN	1013003
210	100	3,2/2,2	36	DKN	1013004
210	115	2,2/1,6	36	8/7/131	1013005
210	115	3,2/2,2	36	8/7/131	1013006
210	90	2,2/1,6	48	8/7/106	1013007
210	90	3,2/2,2	48	8/7/106	1013008
210	100	2,2/1,6	48	DKN	1013009
210	100	3,2/2,2	48	DKN	1013010
210	115	2,2/1,6	48	8/7/131	1013011
210	115	3,2/2,2	48	8/7/131	1013012
250	90	2,2/1,6	36	8/7/106	1013013
250	90	3,2/2,2	36	8/7/106	1013014
250	100	2,2/1,6	36	DKN	1013015
250	100	3,2/2,2	36	DKN	1013016
250	115	2,2/1,6	36	8/7/131	1013017
250	115	3,2/2,2	36	8/7/131	1013018
250	90	2,2/1,6	48	8/7/106	1013019
250	90	3,2/2,2	48	8/7/106	1013020
250	100	2,2/1,6	48	DKN	1013021
250	100	3,2/2,2	48	DKN	1013022
250	115	2,2/1,6	48	8/7/131	1013023
250	115	3,2/2,2	48	8/7/131	1013024



01

02

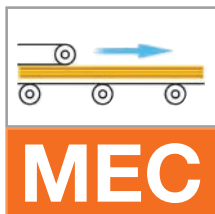


**APPLICATION**

- In multirip machines type “Paul”, “Wemhöner”, “I.S.E.”, etc.
- Suitable for the multiple cutting of decorative panels for the manufacture of laminated parquet and other materials.

**DESCRIPTION**

- Saw blade manufactured with a special steel body for PCD saws with braised tips of Polycrystalline Diamond model “ATTACK®”.
- Nickel coating.
- PCD tip height = 4,2 mm.
- To achieve maximum performance, we advise mounting them on a hydro centric chuck **HYDRO PREZISS Series 6** (See page 141).



10